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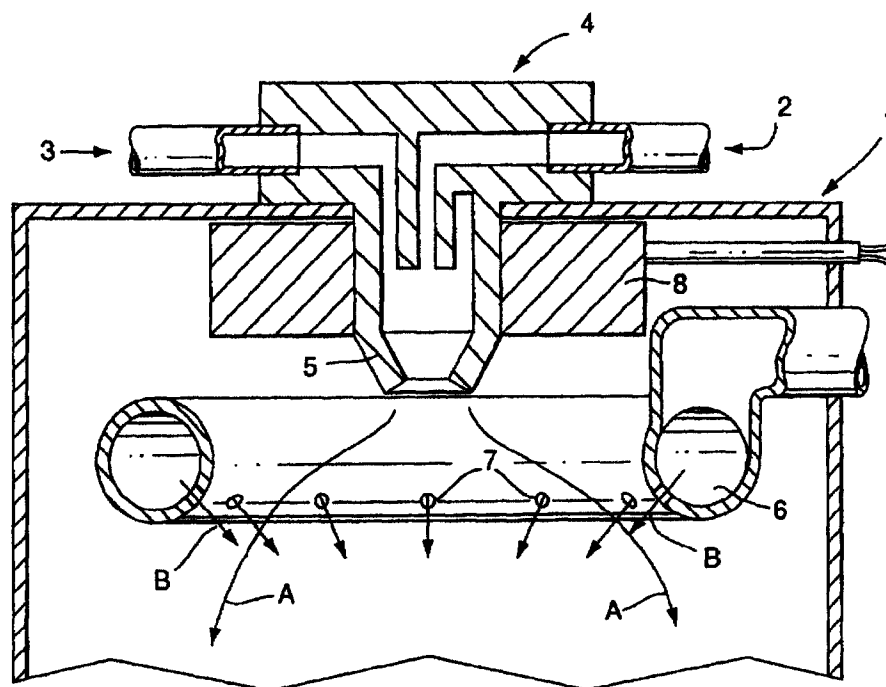
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**(54) Preparation of food products**

**(57)** A method of forming a food product which includes therein a hydrogenated fat, the method compris-

ing contacting a spray of the product in liquid form with a cryogen so as to cool the liquid product and effect a rapid conversion of the liquid product to a solid.



**Description**

[0001] This invention relates to the preparation of food products which comprise or include an hydrogenated fat.

5 [0002] Hydrogenated fats, for example hydrogenated rape seed, hydrogenated palm oil and hydrogenated sunflower seed, are commonly used in the food industry in the production of spreadable food products including table margarine, dairy and non-dairy spreads and peanut butter and in the production of shortenings.

[0003] Shortenings in particular are used in the bakery industry in the production of bread, cakes, biscuits, pastries and the like. For reasons of taste and texture including an ability to control crumb structure in the final product, shortenings are designed to possess a predetermined proportion of fat crystals dispensed in a continuous or substantially  
10 continuous oil phase, for example 15% to 20% fat crystals in solid shortenings and 8% to 12% fat crystals in pumpable shortenings.

[0004] There are well known problems associated with the production of such shortenings and other food products incorporating hydrogenated fats. In particular, the required fat crystalline structure may be difficult to achieve in general and in any event may take such a long time that it imposes undesirable delays and costs in the manufacturing processes  
15 overall.

[0005] For example, table margarine or peanut butter is commonly produced using what is known as "scraped surface technology", in which a molten fat is brought in to contact with a cold surface, for example one cooled by mechanical refrigeration, where it crystallises and is scraped away so that more crystallisation can take place. There are various designs of scraped surface technology apparatus which usually share a common feature of a maximum cooling rate  
20 in the order of 400°C to 600°C per second. Applying such techniques to fats or to mixtures containing fats (such as typical peanut butter mixtures, for example) generally produces crystals of the fat having a particle size typically of 1µm or more.

[0006] In addition, the solid fat phase in shortenings produced by scraped surface technology often continue to crystallise during storage, even when processing is followed by conditioning in cold storage before distribution. This means that shortenings used in baked products at different intervals after processing often contain different levels of solid fat and therefore have different functionality, giving rise to potential variations in the quality of the baked product.

[0007] Another common use for hydrogenated fats is as a stabiliser and to control texture in food products. Many products such as peanut butter contain an oil which is liquid at ambient temperature; there is a potential for phase separation to occur over time, which produces a layer of oil on the surface of the product and which therefore has the effect of lessening the "shelf life" of the product. This problem is usually addressed in commercial products by the addition of fat stabilisers composed of triglyceride or triglyceride/monoglyceride fat mixtures which have a crystalline structure at ambient temperatures; these additives dissolve in the oil phase when the product is hot and, on cooling, gradually crystallise in to a network which entraps the oil phase and thereby reduces the tendency towards phase separation. The presence of these crystals of fat and/or monoglycerides also increases the stiffness of the resulting mixture, which gives a set, or firm, product, and one which is less sensitive to handling or shearing, and having improved spreading properties. In the case of table margarines and dairy and non-dairy spreads, a similar process is designed to produce an aqueous phase dispersion in a network of crystals of fat and/or monoglycerides which provides good spreadability at room temperatures.

[0008] However, in all of these cases, the time required for a stable crystal network to build and for optimum firmness to be reached may take weeks, and the prolonged storage of a food product as an essential element of the manufacturing process is undesirable and costly to the food processing industry and leads to additional cost to the consumer.

[0009] The invention is concerned with an improved method for forming such food products which can generally overcome the difficulties described above with existing methods.

[0010] In accordance with the invention, there is provided a method of forming a food product which includes therein  
45 a hydrogenated fat, the method comprising contacting a spray of the product in liquid form with a cryogen so as to cool the liquid product and effect a rapid conversion of the liquid product to a solid.

[0011] The main aim of the invention is to provide small crystals of liquid fat and a correspondingly large number of these crystals dispersed in a liquid phase of the fat structure.

[0012] Preferably, the rate of cooling of the food product in the method exceeds 1000°C per second, more preferably exceeds 2000°C per second and is advantageously at least 5000°C per second or at least 10000°C per second or higher up to 40000°C or 50000°C or more.

[0013] The spray of liquid fat is advantageously formed by atomisation, preferably by urging the liquid fat through an atomising nozzle in communication with an external source of gas, for example air or nitrogen, under pressure.

[0014] The cryogen is preferably down to a temperature of at least minus 75°C, for example 79.8°C of carbon dioxide snow, or more preferably down to at least minus 185°C, for example minus 194°C of liquid air or minus 196°C of liquid nitrogen. Temperatures between minus 75°C and minus 185°C may usefully be employed by mixing a cryogen, for example liquid nitrogen, with air.

[0015] The liquid food product is preferably directed in to the cryogen by causing the spray thereof to contact a spray

of cryogenic liquid. More preferably, the spray of liquid food product is directed downwardly in to the spray of liquid cryogen which may itself be preferably directed substantially horizontally or upwardly in to a counter-current spray of the liquid food product. This latter method is generally known as "spray crystallisation" and is described in our European Patent Specification No. 0 393 963.

5 [0016] It has been found that the method of the invention, by virtue of its rapid cooling of the liquid food product, produces a product with a crystalline structure of fat particles dispersed in an oil phase which, by variation of the amount of cryogen employed and hence the rate of cooling of the liquid fat droplets, can produce a product with a minimum crystal size and a maximum number of such crystals per unit mass of solid fat in the product.

10 [0017] It has been found that a control of the cooling rate can provide a much smaller crystal size and a corresponding greater number of crystals than can be produced using conventional methods in the food industry. Typically, the crystal size should be 0.5µm or less, ideally 0.1µm or less.

[0018] Because the invention produces such rapid crystallisation, no ordered crystal network is formed and therefore re-crystallised fats are typically shear stable. Also, the multiplicity of very small crystals so formed confers stable rheological properties on the product once it has been brought to ambient temperature. Scraped surface technology processes initiate crystallisation of fat, but the process may continue slowly for days or weeks. This is very significant as the invention can greatly reduce if not obviate the time a food product needs to be stored before it can be used. In preferred embodiments of the invention the product, which after cooling is in particulate form, is brought to ambient temperature and either introduced directly in to a mixture of other food ingredients or mechanically worked (by conventional means such as a pinworker, which produces an extruded plastic solid) and can immediately be introduced in to containers for sale or use, because the completion of crystallisation of the hydrogenated fat is so very rapid.

20 [0019] The invention has been found to be applicable to all hydrogenated fats including hydrogenated rape seed, hydrogenated soya bean, hydrogenated palm oil, hydrogenated sunflower oil and hydrogenated cotton seed. The term "hydrogenated fats" when used herein include those fats which are particularly hydrogenated with a minimum of 5%, more preferably at least 10%, hydrogenation.

25 [0020] Generally, therefore, it has been discovered that the application of rapid cooling rates in accordance with the invention provides a much greater number of crystals of consistent and much smaller average size - typically no more than 0.5 µm - than can be produced utilising conventional cooling process as are used in known food processing methods. This finding provides the basis for reducing the fat content of a variety of foods such as baked products, margarines, dairy and non-dairy spreads, peanut butter, biscuit cream fillings and many more without adversely affecting appearance or organoleptic properties. Moreover, the method of the invention promotes rapid crystallisation, so that the final solid fat content is reached immediately the product is brought to ambient temperature. Crystallisation does not continue over an extended period of time, and therefore the need for costly storage of the products so that crystallisation can take place is obviated.

35 [0021] In addition to the much smaller average size, preferably of no more than 0.5 µm, of the average crystalline particle of fat produced by the method of the invention, there is a significant increase in the overall solid fat content of hydrogenated fat, up to 100% increase over the solid fat content achieved using known methods, for example scraped surface technology. This has considerable advantages for food manufacturers, since this also allows less hydrogenated fat to be used in products such as baked products, margarines, dairy and non-dairy spreads, shortenings, peanut butter, biscuit creams and many more, to provide the same effect. Thus, whether the hydrogenated fat is used as a stabiliser or for some other effect which is ultimately dependent on its solid fat content, up to 50% less hydrogenated fat need be used. This has significant cost implications for food manufacture; there are also important health implications, because hydrogenated fats have high calorific value and contain saturated fatty acids which are held to be harmful in excess and so any means by which these can be reduced is highly desirable.

45 [0022] Food products made by the method of the invention therefore allow for a number of significant advantages for the food industry, in particular:

i) they have increased functionality, particularly in baked products, by virtue of their elevated solid fat content and reduction in fat crystal size. Therefore they can be used in the amounts stipulated by conventional formulations to give an increase in volume, improved crumb structure and uniformity of product quality, provided that the mixing regime used is able to produce a uniform dispersion of the fat throughout the dough/batter used in the baked products.

55 ii) the increased solid fat content increases the functionality of the food product so that lower levels of the fat can be used than those stipulated by conventional formulations to produce products which have the same appearance and organoleptic properties as normal products.

iii) by reducing the amount of solid fat in the product by replacing it with oil before or after applying the method of the invention, a product can be produced which has the same or similar functionality as conventional ones as well

as the same or similar solid fat content. However, there is i) a saving in the amount of the more expensive solid fat used, without sacrifice of functionality and ii) an improvement in the nutritional quality of the product by replacement of the solid fat by an oil containing the more desirable saturated fatty acids.

Thus, it is possible, for example, to formulate fat-rich biscuit cream fillings and similar products used by the baking industry so that they contain less solid fat than is stipulated by conventional formulations. Thus, a typical biscuit cream filling composed of 47% icing sugar, 46.5% fat (partially hydrogenated rape seed oil having a solid fat content of 51% at 20°C) and minor ingredients including flavourings and colourants had similar rheological properties and similar stability as the same formulation containing re-crystallised product whose solid fat content had been reduced to 29% by the addition of unsaturated oil.

iv) Hydrogenated fats which are processed by the invention complete the crystallisation of the solid fat phase immediately after processing once they have been brought to ambient temperature and are extremely stable on storage. Therefore, their use in the production of, for example, baked products does not give rise to the variations in quality with time as often seen in products containing conventionally processed fats.

[0023] For a better understanding of the invention, reference will now be made, by way of exemplification only, to the accompanying drawing showing spray crystallisation apparatus for carrying out the method of the invention and additionally describing specific examples of the fat content of different fats processed in the apparatus.

[0024] With reference to the drawing, there is shown the principal parts of a spray crystallisation apparatus in which, in particular, an atomised food product spray and a cryogen spray are produced and caused to impinge with each other. The apparatus is particularly suited to the use of liquid nitrogen as the cryogen.

[0025] The apparatus shows a cryogenic spray crystallisation head having a body portion shown generally at 1 and, an inlet 2 for the supply of liquid fat thereto and an inlet 3 for the supply of pressurised air thereto. Inlets 2 and 3 lead to an atomising nozzle arrangement 4 top mounted in the body 1 which is designed to break up liquid fat introduced to it in to very small droplets when the fat and air are simultaneously introduced. Commercially available "Venturi" nozzles are preferred. Valves (not shown) are present to control the flow of pressured air and liquid food product to a nozzle outlet 5.

[0026] The resulting spray of atomised liquid food product is shown schematically at 'A'.

[0027] Surrounding the position of the spray A is a hollow cryogen spray ring 6 with a diameter, for example 20cm, sized to surround the anticipated spray maximum size and being concentric with the nozzle 4. The inner and lower surfaces of the spray ring 6 are drilled with an evenly spaced array of small holes 7 selected to suit the flow rates of fat, the required rate of cooling of the fat particles, etc.

[0028] The spray of liquid cryogen is represented by the arrows 'B' which generally converge downwardly and inwardly of the ring 6.

[0029] A heating element 8 is present about the nozzle 4 and terminating above the nozzle outlet 5 to prevent the fat being injected therethrough from solidifying within the nozzle. The amount of heat supplied is regulated and controlled to a desired temperature by a voltage controller (not shown).

[0030] A further heat may be employed around the body portion 1 to prevent any fat from building up on the sides of the apparatus.

[0031] In use of the apparatus, the cryogen spray therefore impinges on the liquid food product spray and causes a very rapid cooling rate on the food product. Solidified food product fall to the base of the apparatus (which may include a plurality of such body portion/spray arrangements) and may be removed therefrom by means, for example, of driven auger.

[0032] The rate of cooling of the liquid food product can conveniently be calculated by known means with particular reference to parameters including the particle size of the fat, the temperature of the fat, the specific heat of the fat, the velocity of the fat particles and the temperature of the cryogen.

[0033] The apparatus shown in the drawing can be readily modified by skilled engineers to suit the use of carbon dioxide snow, liquid air or mixtures of nitrogen with air as alternative cryogens.

[0034] A variety of hydrogenated food products were processed in accordance with the invention using the illustrated apparatus and compared with unprocessed products as described in the following examples.

#### EXAMPLE I

[0035] A very smooth commercial product composed of the following proportions (by weight): roasted peanuts 87.5%, vegetable oil 5.0%, sugar 4.0%, hydrogenated rape seed oil 2.5%, salt 1% was re-crystallised in the apparatus described above at a rate of cooling of about 10500°C per second calculated by means of the parameters described above and including a product particle size of 150µm and a product temperature of 70°C. After re-crystallisation, its firmness (maximum force for penetration) was measured before and after working using cone penetrometry (60 degree

cone angle, 20mm penetration, drive speed 10mm/min). The start temperature was 20°C, and the end temperature was 21°C. Six samples were tested of both a "standard product" and a "re-crystallised product" in accordance with the invention, all before and after re-working. Re-working means vigorous stirring for two minutes. The results are shown in Table 1.

**Table 1**

	STANDARD PRODUCT		RE-CRYSTALLISED PRODUCT	
	At start	After re-work	At start	After re-work
Mean Firmness (grams force)	260.0	66.5	386.3	137.0

[0036] These results show that fats composed of hydrogenated vegetable oil undergo a significant increase in their solid fat index (up to 100% increase) when cryogenically re-crystallised. This leads to a large increase in the hardness of the fat and in the hardness of peanut butter when it is included in the formulation. These stabilisers can therefore be used in reduced concentrations in the peanut butter to produce a product which has the same firmness as a conventionally processed peanut butter and in which the oil dispersion is stable, even after working.

[0037] These results show that:

1. Application of the invention followed by working and filling produces a set peanut butter whose final firmness is reached immediately after filling.
2. Irrespective of the hydrogenated fat stabiliser used, oil separation does not occur, even after vigorous working.
3. When hydrogenated fat is included as a stabiliser in peanut butter, re-crystallisation by the invention leads to a sharp increase in solid fat content compared with products processed by scraped surface technology. Thus, peanut butter processed in this way is significantly firmer and more stable (no oil separation) than the standard product and is much more resistant to working. This means that butters with the same firmness as standard products can be prepared in accordance with the invention using smaller amounts of hydrogenated fat in the formulation.

**EXAMPLE II**

[0038] It has been found that when the fats are melted and re-crystallised using the process of this invention, the fats become harder. This hardening occurs because of a significant increase in the solid fat content and the formation of very large numbers of fat crystals less than 0.5µm. However, the increase in solid fat content, and hence its hardness, depends on the fatty acid composition of the oil used in the hydrogenation process and on its degree of hydrogenation, and hence its degree of saturation. It has been observed that as the degree of hydrogenation (saturation) of fats increases, re-crystallisation in accordance with the invention increases the solid fat content at progressively higher temperatures.

[0039] Typical examples showing the solid fat content (SFC) of standard commercial fats measured at different temperatures against the same materials treated in accordance with the invention (re-crystallised fat) are shown in Table 2.

**Table 2**

	Rape seed low hydrogenation	Rape seed intermediate hydrogenation	Rape seed high hydrogenation	Hydrogenated Palm Oil
Iodine Value	85.0	72.9	53.9	40.0

Table 2 (continued)

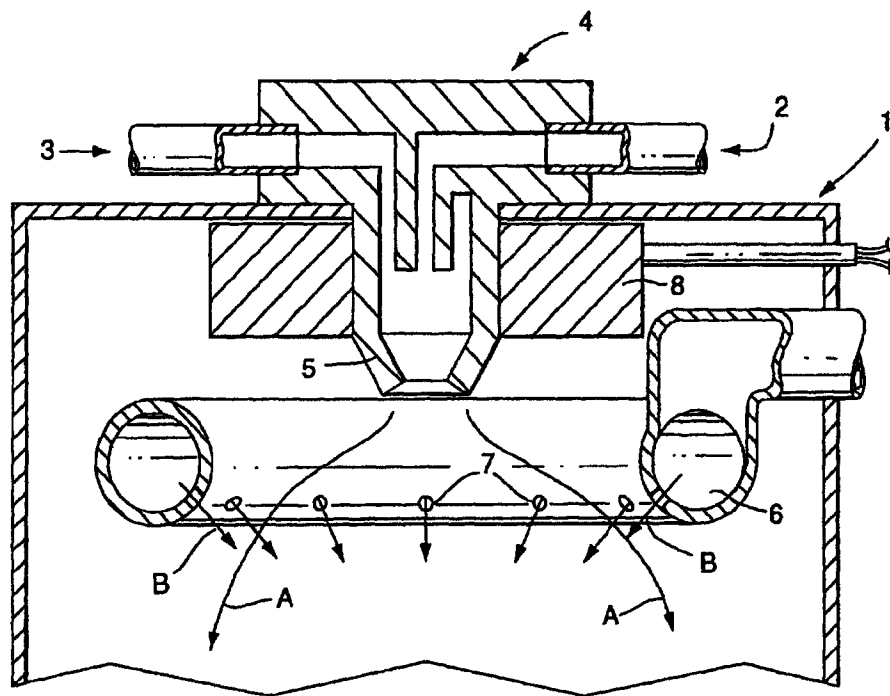
	Rape seed low hydrogenation	Rape seed intermediate hydrogenation	Rape seed high hydrogenation	Hydrogenated Palm Oil
<i>Standard Product</i>	SFC	SFC	SFC	SFC
10°C	7.7	60.0	81.2	74.5
20°C	1.1	50.8	71.5	58.6
30°C	0	38.1	60.7	43.6
35°C	0	16.5	54.3	36.1
40°C	0	0	38.7	24.0
<i>Re-crystallised fat</i>	SFC	SFC	SFC	SFC
10°C	10.2	72.8	90.7	81.3
20°C	1.1	67.2	88.2	76.6
30°C	0.2	39.1	77.1	58.5
35°C	0.1	16.6	64.3	41.8
40°C	0.1	5.6	42.3	23.7

[0040] Hydrogenated fats with an elevated solid fat content have not, it is believed, been available before. Accordingly, the invention extends to any food product containing at least 1% by weight of such hydrogenated fat.

[0041] It is believed that the effects of the invention are applicable to those hydrogenated fats which are already commonly available in hydrogenated form (for whatever purpose), for example soya oil, rape seed oil, cotton seed oil, sunflower oil, peanut oil but is not applicable to those fats which are not hydrogenated, for example almond oil, coconut oil or avocado oil and the like, unless they are artificially hydrogenated before processing in accordance with the invention.

### Claims

1. A method of forming a food product which includes therein a hydrogenated fat, the method comprising contacting a spray of the product in liquid form with a cryogen so as to cool the liquid product and effect a rapid conversion of the liquid product to a solid.
2. A method according to Claim 1 in which the rate of cooling exceeds 1000°C per second.
3. A method according to Claim 1 or Claim 2 in which the rate of cooling exceeds 5000°C per second.
4. A method according to any preceding claim in which the rate of cooling exceeds 10000°C per second.
5. A method according to any preceding claim in which the spray of fat is formed by atomisation.
6. A method according to Claim 5 in which the spray of fat and the cryogen are mixed by means of spray crystallisation.
7. A method according to any preceding claim in which the cryogen is down to a temperature of at least minus 75°C.
8. A method according to any preceding claim in which the cryogen is down to a temperature of at least minus 185°C.
9. A method according to any preceding claim in which a solid is formed comprising fat crystals of a size of 0.5µm or less dispersed in an oil phase.
10. A method according to Claim 9 in which the crystal size is 0.1µm or less.





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(54) **Cryogenic crystallisation of fats**

(57) A method of processing the solid fat phase of a food product which comprises or contains a dispersion of solid fat in an oil phase, the method comprising bringing the solid fat phase with a minimal amount of the oil

phase in a liquid state to a cooling device and there cooling the product to effect fat crystallisation as quickly as possible.



**Description**

[0001] This invention relates to the processing of edible fats and, more particularly, to the processing of edible fats by the addition of crystallised fats to edible oils.

5 [0002] Edible fats and oils consist predominantly of triglycerides. Typically, fats are mixtures of triglycerides, some of which have a melting point higher than room or ambient temperature and therefore contain solids in the form of fat crystals, whereas oils are typically mixtures of triglycerides all of which have low melting points and therefore contain no crystalline fat at room or ambient temperature.

10 [0003] Many food products contain or consist of an oil phase in which fat crystals are dispersed in order to confer some desirable physical or other property. For example, in the case of margarines and spreads, the fat crystals produce a rheology that gives good spreadability when used directly from the refrigerator or at ambient temperatures; for shortenings and other bakery fats, the crystals ensure good volume and fine crumb structure in the final product by allowing bubbles to expand during baking without rupturing; in the case of peanut butter, added crystalline fat immobilises the peanut oil and inhibits unsightly oil separation.

15 [0004] All of these products are commonly made commercially by adding a solid (crystalline) fat to an oil in the desired proportions, heating to melt the solid fat and thereby to produce a solution of the fat in the oil, followed by a cooling phase to crystallise the fat usually in one or more scraped surface heat exchangers of which the "Votator" product is a typical example. During cooling in the scraped surface tubes, crystallisation of the solid fat phase is initiated by the formation of relatively small numbers of crystal nuclei but neither nucleation nor crystal growth is complete by the end  
20 of the cooling process. The progressive growth of fat crystals during storage at 4°C to 10°C in to a three dimensional network increases the hardness of the fat to give a set, firm product. However, this may take weeks to reach completion and the prolonged storage of a food product as an essential element of the manufacturing process is undesirable and costly to the food industry and leads to additional cost to the consumer. Moreover, the size of the fat crystals produced under these conditions of storage or "tempering" is difficult to control and therefore it is often found in practice that  
25 shelf life is variable and that consistency of product quality is difficult to achieve.

[0005] An additional economic consideration is the fact that in scraped surface technology part of the solid fat always remains in solution in the oil phase and does not contribute positively to product functionality; the consequence is that fats can be very unstable and sensitive to temperature cycling, leading to fat crystal growth.

30 [0006] In addition to these limitations, it is important to realise that scraped surface technology is a re-crystallisation technology that influences only the characteristics of what is often the minor phase of a product, namely the crystalline fat. In spite of this, the oil phase, which is often the dominant phase of the food system (for example in margarines and spreads), is processed at the same time without any functional or other benefit to its properties or characteristics. However, this co-processing of oil and fat phases is necessary to obtain intimate association of the oil within the network of fat crystals and to prevent phase separation during storage.

35 [0007] It therefore follows that a major limitation of scraped surface technology is that much higher throughputs of triglycerides are necessary than are influenced by the process, namely only the crystalline components are affected by the cooling process, with unnecessarily high specification of the processing plant and, an increasingly important factor, unnecessarily high energy consumption.

40 [0008] The invention is concerned with a method which is universal in its application to fats or fat/oil mixtures that are to be used as ingredients in more complex food systems. For example, the method of the invention can be effectively used for fats to be used in the manufacture of shortenings and other foods containing a vegetable fat and/or animal fat and/or an interesterified fat, or in the manufacture of foods in which fat is just one of a number of phases, for example margarines, spreads (water dispersed in fat) and herb flavoured butters or margarines (a dispersion of water and particles of herb in fat).

45 [0009] In accordance with the invention, there is provided a method of processing the solid fat phase of a food product which comprises or contains a dispersion of solid fat in an oil phase, the method comprising bringing the solid fat phase with a minimal amount of the oil phase in a liquid state to a cooling device and there cooling the product to effect fat crystallisation as quickly as possible.

50 [0010] The solid fat phase may generally comprise a hydrogenated vegetable or hydrogenated tropical fat, the higher melting point fractions of tropical fats, such as coconut and palm, or butterfat or butterfat fractions or may be a mixture of one or more of these. The disperse phase may generally be any edible oil from vegetable oil to butter oil fractions.

[0011] Preferably, the method is such that only part of the oil phase of the product is processed with the solid fat phase, ie to produce such dispersions of crystals in an oil phase without the need to process all of the oil phase. Instead, the method of the invention provides a method for crystallising only the solid fat component in to numerous crystals  
55 followed by their dispersion in to the remainder of the oil phase by various means. Although crystallisation of the solid fat component may be achieved by scraped surface technology, by drum cooling, by spraying in to a cooling tower or any other method, it has been found that cryogenic spray crystallisation produces fats that are most easily dispersed in an oil phase. Furthermore, cryogenically processed fats generally contain a higher proportion of solid fat than those

processed by other methods and smaller fat crystals - both of which benefit the functionality of the fat phase.

[0012] Generally, the invention contemplates the use of the minimal amount of oil to be processed with the solid fat phase using the method of the invention to allow ready dispersion of the solid fat phase in the complete formulation after cryogenic processing, ie fat crystallisation. For some unhydrogenated hard fats, for example palm stearin, no addition of oil is necessary prior to processing by the method of the invention - such is the ease of dispersion of its crystals when added to oil. For other hard fats, such as some hydrogenated oils, the total oil content of the cryogenically processed solid fat is advantageously 35%, or more preferably 40% (by volume).

[0013] If the solid fat content of the fat is very high and difficult to disperse in an oil, the solid fat component may be processed with a minimal amount of the oil phase, for example 5% to 10% (by volume) of the total oil phase, but this has been found to depend on the chemical composition and crystal habit of the fat in question. Thus, whereas it has been found that partially hydrogenated rapeseed oil with a solid fat content of more than 90% (by volume) at 20°C required the addition of some oil before cryogenic spray crystallisation for it subsequently to be dispersible in an oil phase (Example 1), palm stearin with a similar solid fat content could be dispersed in oil after re-crystallisation without any such prior addition of oil.

[0014] Alternatively, in some applications, the cryogenically re-crystallised solid fat component (such as hydrogenated rapeseed oil) may be added to an oil phase indirectly. For example, re-crystallised solid fat and oil may be added separately to a complex mixture of ingredients, for example doughs and batters, without loss of fat functionality so that solid fat and oil interact only during the mixing process (see Examples 4 and 5). In such cases there is no need to form a shortening by combining fat and oil components.

[0015] In accordance with aspects of the invention, the crystallisation of fat using a cryogen, or any other cooling medium, is followed by the return of the fat or fat/oil mixture to ambient temperature from that of the cooling medium and is then mixed and/or blended with the remainder of the oil phase (or other food ingredients) to complete the final composition of the product. In the method of the invention, this mixing and/or blending may be achieved at a temperature selected to give the desired solid fat content in the product by a number of methods, all of which produce a uniform dispersion of the fat crystals in the oil phase. For example, in the manufacture of shortenings and margarines it has been found that gentle mixing of the solid fat with the added oil (and other ingredients) followed by passage through a pin-worker or an extruder (at any chosen temperature) produces a continuous stream of product that is similar in appearance and mechanical properties to that produced by scraped surface technology after some days of storage.

[0016] Cryogenic re-crystallisation of hard fats produces fat crystals that are smaller than can be achieved using other commercially employed technologies such as scraped surface technology. Such crystals have enhanced functionality in foods such as baked products such that they can be used in smaller amounts than conventionally produced fats without loss of "mouthfeel" or appearance. The addition of oil to these fats to produce a dispersion of fat crystals in the oil phase in accordance with the invention does not subsequently have an adverse effect on the enhanced functionality of the small fat crystals, unless of course the temperature is allowed to rise above the melting point of the crystalline fat. Thus, using a plastic shortening produced from cryogenically re-crystallised hard fat in accordance with the invention, it has been found possible to prepare laminated pastry with at least 20% (by volume) less fat than in conventional products and without loss of quality criteria.

#### EXAMPLE 1

[0017] A biscuit shortening comprising one part partially hydrogenated rapeseed oil (iodine value 53.9) as the disperse phase and 3 parts rapeseed oil as the continuous phase was prepared in a Schröder scraped surface heat exchanger to give a final solid fat content at 20°C of 21% (by volume). This was the control sample. Its firmness (maximum force for penetration) was measured using cone penetrometry (60 degree cone angle, 20mm penetration, drive speed 10mm/min) at 20°C. Six samples were tested.

[0018] A shortening of identical ingredient composition was prepared by melting the hydrogenated rapeseed oil, adding to it 10%  $v/v$  of the rapeseed oil ingredient and then re-crystallising the mixture by spraying it in to a field of liquid nitrogen. The resulting frozen powder was allowed to return to ambient temperature and the remainder of the rapeseed oil added to it and the whole stirred gently for 5 minutes before passing through a pin-worker maintained at 20°C. The shortening that emerged (solid fat content 24.5%) was similar in appearance to the scraped surface control and its firmness was then measured as described above. The results are shown in Table I below.

TABLE I

The firmness (mean force (g)) of shortenings prepared by conventional and cryogenic processing.		
	Scraped Surface Control	Cryogenically Processed
Mean Firmness (grams force)	305	360
Standard Deviation	22.4	25.8

**EXAMPLE 2**

[0019] A shortening comprising one part partially hydrogenated rapeseed oil (iodine value 72.9) as the disperse phase and 2.5 parts rapeseed oil as the continuous phase was prepared in a scraped surface heat exchanger and mechanically tested as described above in Example 1. Its solid fat content was 15.5% (by volume) at 20°C.

[0020] A shortening of identical composition was prepared by melting the partially hydrogenated rapeseed oil and then re-crystallising it by spraying in to a field of liquid nitrogen. The resulting frozen powder was returned to ambient temperature and the rapeseed oil component of the shortening added to it and stirred slowly for 5 minutes before passing it through a screw-fed pin-worker maintained at 20°C. The resulting shortening (solid fat content 19% (by volume)) was similar to the control in appearance and its firmness measured as described above in Example 1. The results are shown in Table II below.

TABLE II

The firmness (mean force (g)) of shortenings prepared by a conventional scrape surface method and cryogenic processing.		
	Scraped Surface Control	Cryogenically Processed
Mean Firmness (grams force)	230	291
Standard Deviation	15.7	19.1

[0021] In both Examples I and II, the firmness of the cryogenically processed fat could be adjusted more closely to match that produced by scraped surface technology simply by adding an appropriate amount of oil to the formulation immediately prior to cryogenic re-crystallisation of the solid phase.

[0022] Furthermore, it has been found that dispersion by mechanical means of the crystals of a cryogenically re-crystallised hydrogenated solid fat in an oil phase is typically successful provided that the cryogenically re-crystallised solid fat contains an oil phase that represents at least 35% to 40% (by volume) of the re-crystallised fat.

[0023] It should be noted that with unhydrogenated fats such as palm stearin the amount of oil in the hard fat start material can be as low as, for example 5% to 8% (by volume), such is the ease of dispersion of its crystals when the remaining oil is added.

**EXAMPLE 3**

[0024] Margarines are prepared commercially by passing all of the ingredients including fat and aqueous phases, through a scraped surface heat exchanger followed by a period of storage to allow fat crystallisation to be completed. In the method of the invention, it is also possible to make a margarine by taking the solid fat component, together with a minimal amount of the oil phase, cryogenically re-crystallising it and then combining it with an emulsion of the aqueous phase dispersed in the remainder of the oil phase or by adding the oil and aqueous phases sequentially.

[0025] Cryogenically re-crystallised, partially hydrogenated rapeseed oil (iodine value 72.9) containing 0.5% (by volume) of a commercial distilled monoglyceride was brought to room temperature. To one part of this powder was added to two parts of a water-in-oil emulsion of the following composition; the aqueous phase composition was similar to that used in many commercially produced margarines.

rapeseed oil	50.0%
water	46.5%
reconstituted buttermilk	2.0%

(continued)

salt	1.4%
potassium sorbate	0.4%
lactic acid	0.4%
flavour and colour	0.3%

[0026] They were then thoroughly mixed together by passage through a screw-fed pin-worker to produce a plastic product similar in appearance and hardness to margarine of the same composition produced by scraped surface technology (see below). Alternatively, it has been found that if the fat powder is added to the same proportions of rapeseed oil and aqueous phase and thoroughly mixed, a margarine is produced that is similar to that prepared by addition of an emulsion to the fat powder. These water-in-oil emulsions (margarines) were found to be stable for several weeks when stored at refrigeration temperature with little or no evidence of phase separation. The results are shown in Table III.

TABLE III

A comparison of the firmness of a margarine produced by scraped surface technology with one made using cryogenically re-crystallised fat to which other ingredients have been added by mixing.		
	Scraped Surface Control	Cryogenically Processed
Mean Firmness (grams force)	210	232
Standard Deviation	19.9	14.2

**EXAMPLE 4**

[0027] Partially hydrogenated rapeseed oil (iodine value 71.5, solid fat content 54.2% (by volume) at 20°C) was melted and re-crystallised cryogenically by spraying in to a field of liquid nitrogen. The resulting frozen powder was returned to ambient temperature and used with other ingredients to make a sweet biscuit dough according to the following formulation.

250g	self raising flour
125g	castor sugar
80g	rapeseed oil
45g	fat powder (partially hydrogenated rapeseed oil)
15g	milk
0.1g	vanilla essence

[0028] The amount of oil in this formulation represented the amount necessary to reduce the solid fat content of the solid fat component to about 20% (by volume) at 20°C. The solid fat powder was blended with the sugar and the oil added subsequently to produce a cream. The remainder of the ingredients were then added and blended with the fat/sugar mixture to produce a dough that was machined, cut out and baked.

[0029] The resulting biscuits were allowed to cool and measurements made of their diameter and specific volume.

[0030] Biscuits of the same formulation were also made using a) a shortening prepared by adding the re-crystallised solid fat to the oil and mixing until they formed a homogeneous solid and b) a shortening of the same composition and materials as a) but which had been melted and re-crystallised using the cryogenic spray crystallisation method described above.

[0031] The results obtained are shown in Table IV.

TABLE IV

Characteristics of biscuits prepared from 3 fats of identical composition but in which the crystalline and oil components were mixed in different ways. Shortening 1 prepared by blending cryogenically re-crystallised fat with oil. Shortening 2 prepared by melting shortening 1 followed by cryogenic re-crystallisation.			
n=100	Solid Fat + Oil Added Separately To Dough	Shortening 1	Shortening 2
Mean Specific Volume (g/mm <sup>3</sup> ) ±SD*	0.71±0.03	0.74±0.04	0.73±0.04
Mean Diameter (mm) ±SD	83±2	84±3	84±2

\* Standard Deviation

[0032] These results show that, irrespective of the way in which the crystalline and oil components of the fats were presented to the other ingredients of the biscuit doughs, fat functionality was unaffected and similar results were obtained in all of the final products.

**EXAMPLE 5**

[0033] Partially hydrogenated rapeseed oil (iodine value 71.5, solid fat content 54.2% (by volume) at 20°C) was melted and re-crystallised cryogenically by spraying in to a field of liquid nitrogen. The resulting frozen powder was returned to ambient temperature and used, with other ingredients, to make bread in batches of 10 loaves, each batch testing the baking performance of a different fat blend. A modification of the Chorleywood Baking Process was used and the bread formulation of each batch was as follows:

4,500 g	hard white flour
140 g	fat
120 g	fresh, compressed yeast
50 g	salt
10 g	sugar
2,650 g	water

[0034] The fats used comprised one of a) the re-crystallised fat powder, to which sufficient rapeseed oil had been added to reduce the solid fat content to 30% (by volume) at 20°C and mixed until it produced a homogeneous solid (shortening), b) the same fat as in a) that had been melted and re-crystallised using the cryogenic spray crystallisation method described above to produce a powdered shortening, c) the same fat powder and oil components used in a) and b) but added separately to the other dough ingredients in the mixer, or d) a control shortening in which the cryogenically re-crystallised fat powder and oil mixture referred to in b) had been melted and processed through a scraped surface heat exchanger. This experiment was designed to establish whether the way in which cryogenically re-crystallised fat (crystals) was presented to the other dough components affected loaf quality.

[0035] The ingredients were mixed according to the short time, high energy method using a "Tweedy" 10 mixer (10Whkg<sup>-1</sup>). The loaves were moulded and proofed for a total of 2 hours at 40°C (1 hour proof, knock down followed by a second proof of 1 hour) using a relative humidity of 80%. Baking was at 215°C for 30 minutes after which loaves were cooled overnight at ambient temperature before they were assessed and measurements made. Loaf volume was measured using seed displacement and an average value of 10 loaves per batch calculated. Texture score was conducted by expert assessment on a scale of 0 (very bad) to 6 (excellent/ exhibition). The results are shown in Table V below.

TABLE V

Characteristics of loaves prepared from 4 fats of identical triglyceride composition but in which the crystalline and oil components were mixed in different ways. Shortening 1 prepared by blending cryogenically re-crystallised fat with oil. Shortening 2 prepared by melting shortening 1 followed by cryogenic re-crystallisation. Control shortening prepared by scraped surface processing.				
	Shortening 1	Shortening 2	Solid Fat + Oil Added Separately To Dough	Control Shortening
Average Loaf Volume (ml)	1,525 $\pm$ 10	1,532 $\pm$ 11	1,555 $\pm$ 16	1,475 $\pm$ 21
Average Crumb Texture Score	4.5 $\pm$ 0.1	4.5 $\pm$ 0.1	4.2 $\pm$ 0.2	3.7 $\pm$ 0.1

[0036] These results show that, irrespective of the way in which the crystalline and oil components of the fats were presented to the other ingredients of the bread doughs, fat functionality was unaffected and similar results were obtained in all of the final products containing cryogenically re-crystallised fat. In particular, re-crystallised fat and oil components added separately to doughs performed as well as reconstituted shortenings in which there was a fine dispersion of fat crystals in the oil phase. As expected, the bread containing fat processed conventionally, by scraped surface technology, had smaller volumes and lower crumb texture scores.

#### EXAMPLE 6

[0037] Laminated pastry, used in such products as vol au vent cases, croissants and puff pastries, contains a relatively large amount of fat, which may be a vegetable shortening (or margarine based or vegetable oils) or butter. For best results, the proportion of fat is as high as 100% (by volume) of the flour weight or between 35% and 40% (by volume) of the total paste. It is widely known that significant reductions of these levels produce pastries with poor lift in the oven and with unacceptable shrinkage after cooling.

[0038] The vegetable shortenings or margarines used in these products usually consist of or contain a solid fat phase of partially or completely hydrogenated vegetable fat dispersed in a vegetable oil. It is common commercial practice to produce these fat blends using machines of the "Perfector" or "Votator" type.

[0039] However, it has been found that when the performance of commercial vegetable shortenings, or margarines containing or consisting of a hydrogenated fat, in laminated pastry is compared with fat of the same chemical composition that has been prepared by the method of the invention, namely by cryogenically re-crystallising hard fat, and later blending with oil to adjust the solid fat content, the functionality of the pastry fat prepared from cryogenically re-crystallised fat is so improved that reductions of up to 35% (by volume) in the fat level results in products that are similar in appearance and mouthfeel to those containing normal amounts of the commercially prepared fat. Details of some typical results that have been obtained are given in Tables VI and VII. It is believed that such reductions of fat content in laminated pastry products, without loss of product quality, have not been achieved before using alternative approaches or technologies.

[0040] This increase in functionality of cryogenically re-crystallised fat is attributed to the significant reduction in fat crystal size, the corresponding increase in fat crystal numbers, as well as the increase in solid fat content of the hydrogenated vegetable fat component of the shortening or margarine. Indeed, the increase in solid fat content of flaky pastry shortenings containing a hydrogenated fat, after processing by the method of the invention, may be such that the fat firmness also increases significantly and the rheological properties of the fat may no longer be suitable for even lamination. It is a considerable benefit of the method of the invention in this application that in such cases the shortening may be re-formulated to increase the proportion of oil (with a corresponding decrease in the proportion of hydrogenated fat) such that when re-crystallised using the method of the invention, the rheological properties of the fat fall within limits that permit lamination to be carried out. In this way, the level of saturated, hydrogenated fat in the formulation can be reduced, with concomitant cost benefits to the producer and nutritional benefits to the consumer.

[0041] The composition of laminated pastry used in tests is as follows. Each control and experimental pastry was prepared in 100kg batches using a commercial laminating machine and baked in commercial ovens.

Ingredient	% On Flour Weight	% Of Total
Flour	100	43.33

(continued)

Ingredient	% On Flour Weight	% Of Total
Water	55	23.83
Vegetable shortening	75	32.50
Salt	0.8	0.34

TABLE VI

Composition and properties of commercial vegetable shortenings used to prepare laminated (puff) pastry to include their Solid Fat Index (SFI) and Fat Firmness.

Fat Blend		SFI (%) at 20°C	Fat Firmness (g/cm <sup>2</sup> )
<b>A</b>	Hydrogenated Palm Oil + Rapeseed Oil	37	380
<b>B</b>	Partially Hydrogenated Soya Bean Oil + Soya Oil	42	410
<b>C</b>	Hydrogenated Rapeseed Oil + Palm Oil + Rapeseed Oil	43	450

TABLE VII

Effect of the three commercial vegetable shortenings (Commercial A, B and C) of Table VI, prepared using scraped surface technology, and of shortenings of the same chemical composition but re-crystallised and blended with oil according to the method of the invention (Re-crystallised A, B and C), on some of the characteristics of laminated (puff) pastry.

Fat Blend	Level of Fat Used (% Of Normal Fat Content)	Height Of Pastry (mm)	Palate Cling
<b>Commercial A</b>	100%	2.95	Moderate
<b>Commercial A</b>	70%	1.52	Moderate
<b>Re-crystallised A</b>	70%	3.05	Slight
<b>Commercial B</b>	100%	3.77	Moderate
<b>Commercial B</b>	70%	1.82	Moderate
<b>Re-crystallised B</b>	70%	3.65	Slight
<b>Commercial C</b>	100%	3.55	Slight
<b>Commercial C</b>	70%	1.88	Moderate
<b>Re-crystallised C</b>	70%	3.40	Slight

[0042] The results shown in Table VII show that, as expected, reducing the level of fat to 70% of the normal value results in a significant loss of pastry lift. However, such is the baking performance of fats of the same chemical composition prepared by the method of the invention that using the same low fat levels produces pastry lift and "mouthfeel" equivalent to the higher levels of conventional fat produced by scraped surface technology.

## Claims

1. A method of processing the solid fat phase of a food product which comprises or contains a dispersion of solid fat in an oil phase, the method comprising bringing the solid fat phase with a minimal amount of the oil phase in a liquid state to a cooling device and then cooling the product to effect fat crystallisation as quickly as possible.
2. A method according to Claim 1 in which only part of the oil phase of the product is processed with the solid fat phase.
3. A method according to Claim 1 and Claim 2 in which the minimal amount of oil to be processed with the solid fat

phase using the method of the invention is that which allows ready dispersion of the solid fat phase in the complete formulation after cryogenic processing.

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4. A method according to any preceding claim in which the amount of oil is at least 35% (by volume) of the solid fat phase.
5. A method according to Claim 4 in which the amount of oil is at least 40% (by volume) of the solid fat phase.
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6. A method according to any preceding claim in which the product after cooling is mechanically worked with the remainder of the oil phase and/or other ingredients of the formulation to produce a product in which there is a uniform dispersion of the solid fat phase.

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